

Date: Monday, 5/1/2006 4:00:04 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GUIDE	
Job Number	: 26888		Part Number	: D31373	
Estimate Number	: 11073		Drawing Number	: D3137 REV D E <i>CP 06.05.02</i>	
P.O. Number	:		Project Number	: N/A	
This Issue	: 5/1/2006	S.O. No. :	Drawing Revision	: D E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type :	MACHINED PARTS	Due Date	: 5/13/2006
Previous Run	:		Qty:	32	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev A 02.05.29 New Issue NG				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	MDELRLINB075X1250	Delrin Bar			
Comment: Qty.: 0.0831 f(s)/Unit Total : 2.4917 f(s) Matl:Black Delrin bar 1.250" x .750" (ref DART spec. M-DELRIN-B) Batch: <i>M 100724</i> <i>J. G 06105/18 32</i>					
2.0	BAND SAW	BAND SAW			
Comment: BAND SAW Cut Blanks.Bank size: 1.250" x .750" x .950" long <i>J. G 06105/18 32</i>					
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1			
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA242 & Dwg D3137 2-Deburr <i>J. G 06105/18 32</i>					
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J. G 06105/18 32</i>					
5.0	QC8	SECOND CHECK			
Comment: SECOND CHECK <i>J. G 06105/18 32</i>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: SD Date: 06/05/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 4:00:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 26888

Part Number: D31373

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST410

SP 06/05/18

(32)

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/19

Job Completion



U 06.05.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26888
Description: Guide	Part Number:	D3137-3
Inspection Dwg: D3137 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>S.G</u>	Audited by: <u>Tnf</u>	Prototype Approval: N/A
Date: <u>06/05/18</u>	Date: <u>06/05/18</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	04.11.12	0.175 was 0.145 & Ø0.65 x 100° was Ø0.75 x 100°	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	

DART

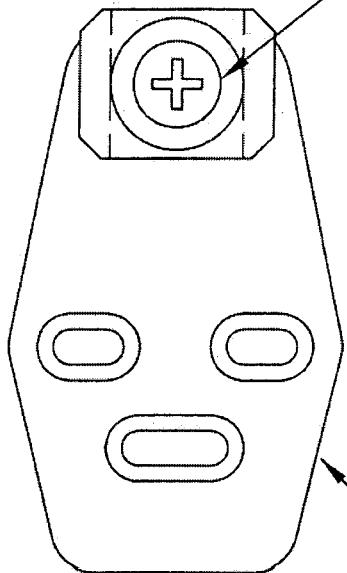
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED

05.12.09

A	02.04.17	NEW ISSUE
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.
C	03.08.15	ADD -043
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS
E	05.11.23	ADD -045

MS24694-S101 SCREW
D3137-5 WASHER
D3137-3 GUIDE
INSTALL ON SAME SIDE AS C'SINKS
(OPPOSITE SIDE FROM RIDGES)



D3137-1 BRACKET (-041 SHOWN)
OR
D3137-7 BRACKET (-043 SIMILAR)
OR
D3137-9 BRACKET (-045 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN)
D3137-043 BRACKET ASSEMBLY (SIMILAR)
D3137-045 BRACKET ASSEMBLY (SIMILAR)

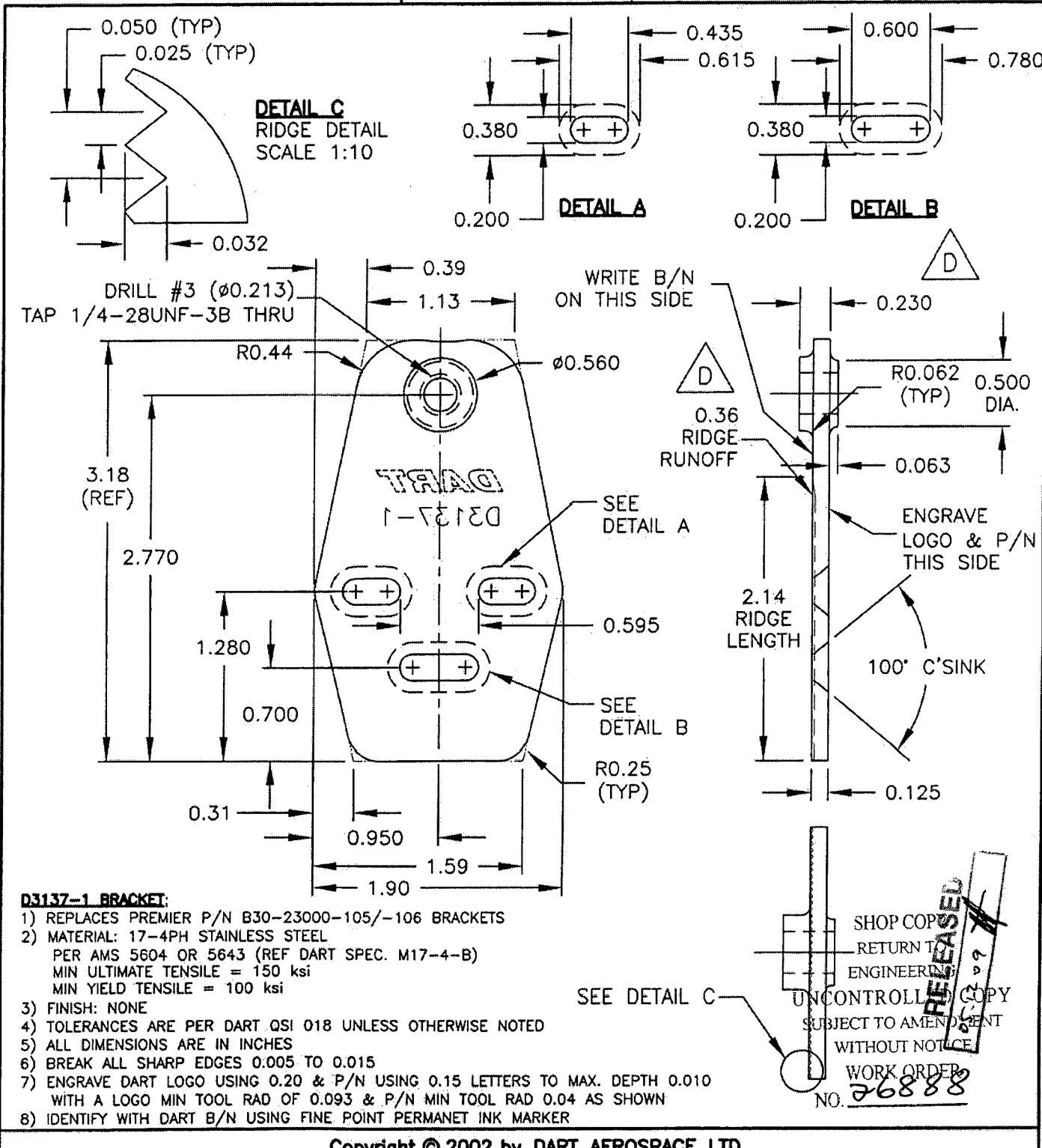
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DATE		TITLE SCALE 05.11.23 BRACKET ASSEMBLY 1:1

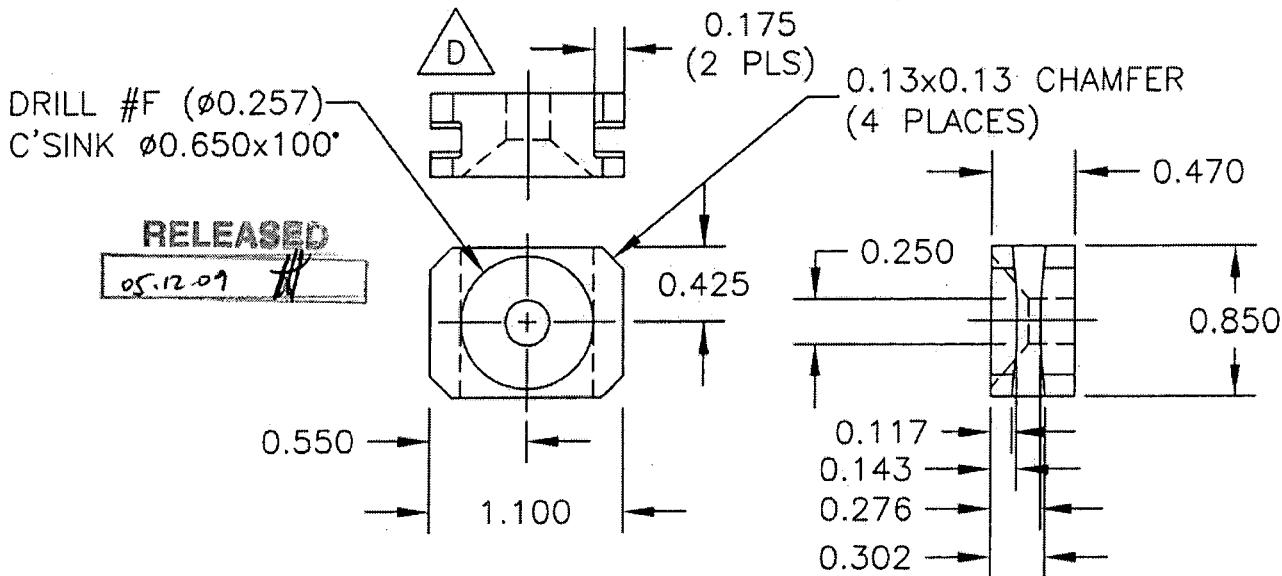


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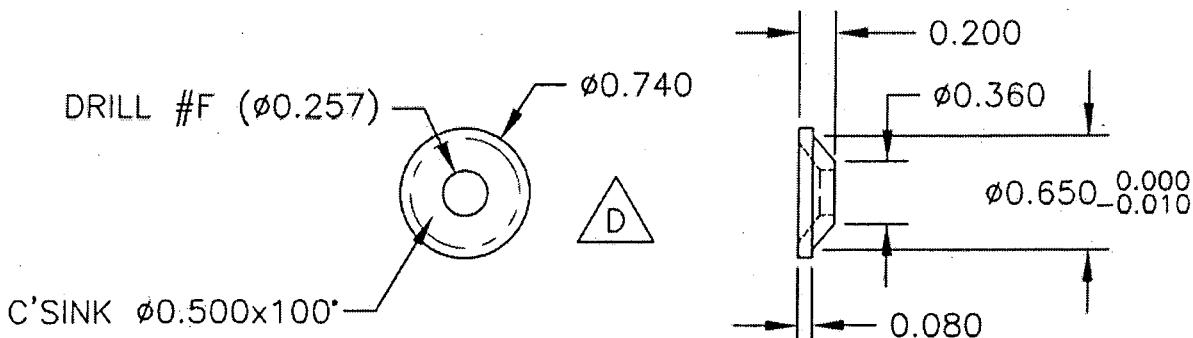
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3137-3 GUIDE**

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

**D3137-5 WASHER**

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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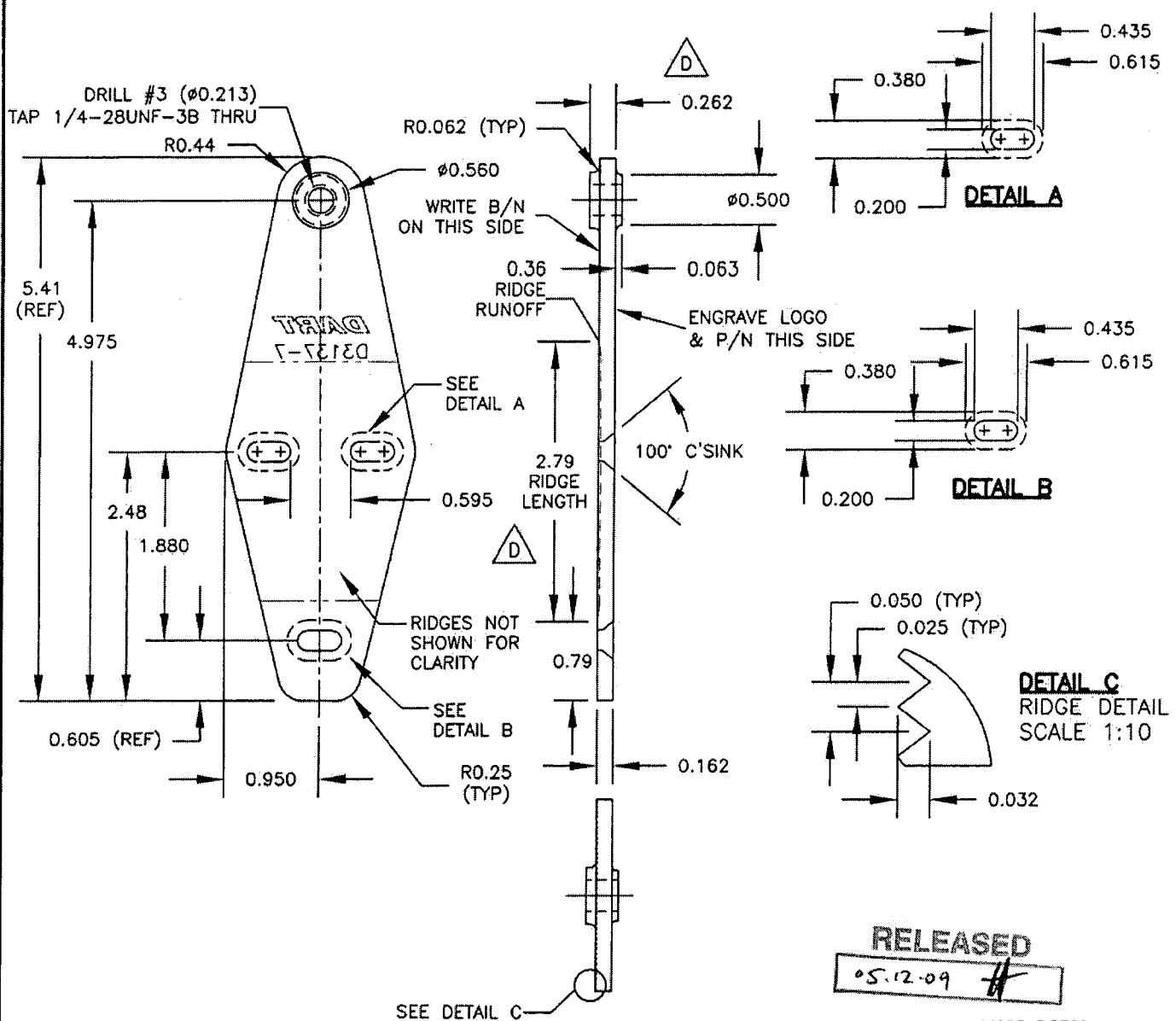
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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 2:3



D3137-7 BRACKET:

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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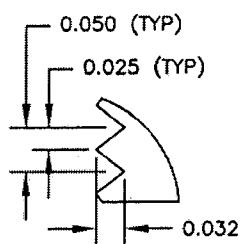
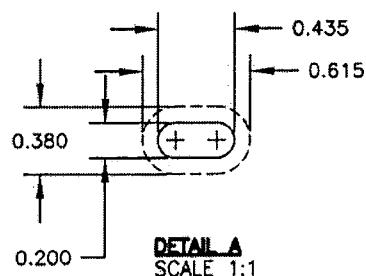
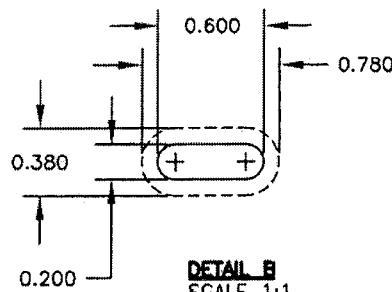
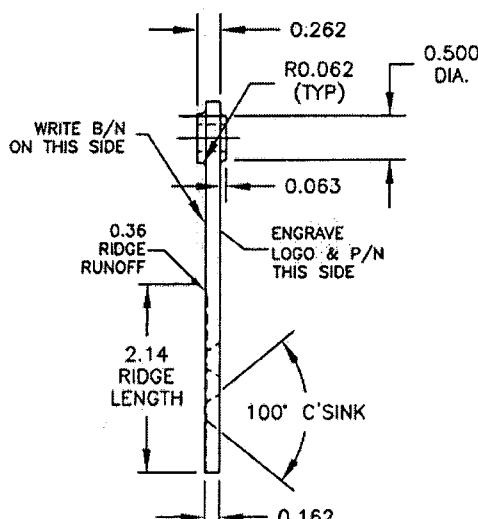
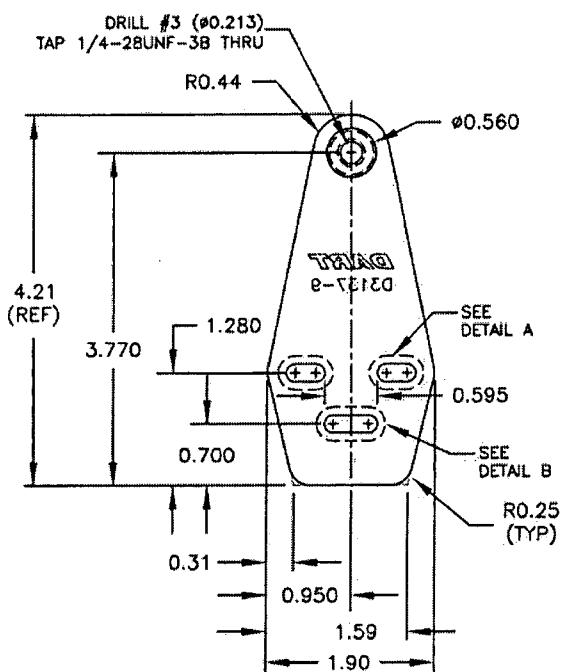
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DATE 05.11.23		TITLE BRACKET ASSEMBLY SCALE 1:2

**DETAIL C**
RIDGE DETAIL
SCALE 1:20**DETAIL A**
SCALE 1:1**DETAIL B**
SCALE 1:1**D3137-9 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
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